

वस्त्रादि — करघों के लिए चमड़े के पिकिंग  
बैंड — विशिष्टि

( दूसरा पुनरीक्षण )

Textiles — Leather Picking Bands for  
Looms — Specification

( Second Revision )

ICS 59.120.30

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## FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Textile Machinery and Accessories Sectional Committee had been approved by the Textiles Division Council.

Picking band is a flexible strap which is connected between picking stick or arm and the picker. It is one of the part for pick insertion process. With the help of picking band, picker strikes with the shuttle which carry the purn.

This standard was originally published in 1958 and subsequently revised in 1972. This revision has been made in the light of experience gained since its publication and to incorporate the following major changes:

- a) Title of the standard has been modified;
- b) Marking clause has been modified;
- c) Packing and sampling clauses have been incorporated; and
- d) References to Indian standards have been updated.

In formulation of this standard, technical assistance has been derived from ISO 22843 : 2020 ‘Rubber bands — General requirements and test methods’ issued by the International Organization for Standardization.

The composition of the committee responsible for the formulation of this standard is listed in Annex A.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 ‘Rules for rounding off numerical values (*second revision*)’. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard*

# TEXTILES — LEATHER PICKING BANDS FOR LOOMS — SPECIFICATION

( *Second Revision* )

## 1 SCOPE

This standard prescribes requirements of leather picking bands, plain or hairy made from ox or buffalo hide.

## 2 REFERENCES

The standards listed below contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards listed below.

<i>IS No.</i>	<i>Title</i>
IS 582 : 1970	Methods of chemical testing of leather ( <i>first revision</i> )
IS 5914 : 1970	Methods of physical testing of leather
IS 2500 (Part 1) : 2000	Sampling procedures for inspection by attributes: Part 1 Sampling schemes indexed by acceptance quality limit (AQL) for lot by lot inspection ( <i>third revision</i> )

## 3 MATERIAL

Ox or buffalo hide chrome or vegetable and oil tanned as may have been agreed upon between the buyer and the seller or as may have been declared or marked.

## 4 REQUIREMENTS

All the bands in cut lengths, butt lengths or intermediate lengths are generally of comparable quality as long as they are cut from the butt portion of the hide.

### 4.1 Dimensions — See Table 1.

### 4.2 Physical and Chemical Requirements

Irrespective of whether the bands in a lot are plain or hairy, the bands shall comply with the applicable requirements of Table 2.

### 4.3 Freedom from Defects

Picking bands shall be visually free from warble holes, deep fly cuts, bacterial damages or any other defect likely to affect their life or usefulness.

## 5 MARKING

### 5.1 Cross (x) on the butt end and punch (o) on the shoulder end shall be marked on each picking band.

NOTE — Usually butt end is tied to the picker to obtain a longer working life of picking band.

**Table 1 Dimensions of Ox and Buffalo Hide Picking Bands, Plain and Hairy**

(Clause 4.1)

All dimensions in millimetres

<b>Sl No.</b>	<b>Width</b>	<b>Thickness</b>	<b>Length of Cut Bands</b>	<b>Length of Butt Bands</b>
			<i>Min</i> (4)	<i>Min</i> (5)
i)	32.0	5	600	1200
	or 35.0	or 6		
Tolerance	+ 1.0 - 0.5	± 1	-	-

NOTE — All picking bands in a lot shall be either plain or hairy and cut bands or butt bands as may have been agreed upon between the buyer and the seller or as may have been declared or marked.

**Table 2 Physical and Chemical Requirements of Picking Bands**  
*(Clause 4.2)*  
 (for both ox hide and buffalo hide)

Sl No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Tensile strength: a) Ox hide b) Buffalo hide	250 kgf/cm <sup>2</sup> , <i>Min</i> 350 kgf/cm <sup>2</sup> , <i>Min</i>	LP : 6 of IS 5914
ii)	Elongation at break	80 percent, <i>Max</i>	
iii)	Shrinkage temperature: a) Chrome tanned [in glycerine water (40 : 60) solution] b) Vegetable and oil tanned (plain water)	108 °C, <i>Min</i> 80 °C, <i>Min</i>	LP : 10 of IS 5914
iv)	Free oils and fats	35 percent, <i>Max</i>	LC : 4 of IS 582
v)	Moisture content	12 percent, <i>Max</i>	LC : 2 of IS 582

**5.2** Each packages/carton of picking band shall also bear the following information:

- a) Manufacturer's name, initials or trade-mark, if any;
- b) Type of the leather;
- c) Net weight of the content;
- d) Code number to trace back the history of production;
- e) Dimension of picking bands;
- f) Number of picking bands in lot;
- g) Gross and net mass;
- h) Lot/batch number;
- j) Country of origin; and
- k) Any other information required by the law in force and/or by the buyer.

### 5.3 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the

products may be marked with the Standard Mark.

### 6 PACKING

Picking bands shall be packed in cases/cartons strong enough to withstand normal hazards of storage and transport. Details of the packing shall be as agreed to between the buyer and the seller. Packaging of the product shall be such as to maintain the integrity of the product throughout its shelf life.

### 7 SAMPLING

**7.1** All the picking bands manufactured from the same raw material delivered to a buyer against a despatch note shall constitute a lot.

**7.2** The conformity of the lot to the requirements of this standard shall be determined on the basis of the tests carried out on the samples selected from it.

**7.3** Unless otherwise agreed to between the buyer and the seller, the number of picking bands to be selected at random from a lot shall be in accordance with col (2), col (3) and col (5) of Table 3 [*see also IS 2500 (Part 1)*].

**Table 3 Sample Size and Permissible Number of Nonconforming Picking Bands**  
*(Clauses 7.3 and 7.4)*

Sl No.	Lot size	No. of Picking Bands to be Selected for Testing Dimensions	Permissible No. of Non-Conforming Picking Bands amongst those Selected in Col (3)	No. of Picking Bands to be Selected for Determining Mass from amongst those Selected in Col (3)
(1)	(2)	(3)	(4)	(5)
i)	Up to 150	8	1	3
ii)	151 - 280	13	1	3
iii)	281 - 500	20	2	3
iv)	501 and above	32	3	5

**7.4** The number of picking bands to be tested and criterion for conformity for each of the characteristics shall be as follows:

<i>Characteristic</i>	<i>No. of Picking Bands to be Tested</i>	<i>Criterion for Conformity</i>
Dimensions and freedom from defects	According to col (3) of Table 3	Non-conforming bands not to exceed the corresponding number given in col (4) of Table 3
Tensile strength, Elongation at break, Shrinkage temperature and all other requirements	According to col (5) of Table 3	Each observed value satisfies the requirements

**ANNEX A**  
*(Foreword)*

**COMMITTEE COMPOSITION**

Textile Machinery and Accessories Sectional Committee, TXD 14

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This Indian Standard has been developed from Doc No.: TXD 14 (20112).

### Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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